NAVAL AIR PROPULSION CENTER

TRENTON, NEW JERSEY 08628



NAPO-PE-23 NASA-CR-165388

ROTOR FRAGMENT PROTECTION PROGRAM: STATISTICS ON AIRCRAFT
GAS TURBINE ENGINE ROTOR FAILURES THAT OCCURRED IN U. S.

COMMERCIAL AVIATION DURING 1978

By R. A. DELUCIA & J. T. SALVINO

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This report presents statistical information relating to the number of gas turbine engine rotor failures which occurred during 1978 in commercial aviation service use. The predominant failure involved blade fragments, 82.4 percent of which were contained. Although fewer rotor rim, disk and seal failures occurred, 33.3%, 100% and 50% respectively were uncontained. Sixty-five percent of the 166 rotor failures occurred during the takeoff and climb stages of flight.

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COMMERCIAL AVIATION DURING 1978

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7. E. ELSASSER

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INTRODUCTION

This report has been prepared as part of the Rotor Fragment Protection Program (RFPP), which is sponsored by the National Aeronautics and Space Administration (NASA) and conducted by the Naval Air Propulsion Center (NAPC). The objective of the RFPP is to develop criteria for the design of devices that will be used on aircraft to protect occupants and the aircraft structure from the potentially lethal and devastating fragments that are generated by gas turbine engine rotor failures.

Presented in this report are statistics on gas turbine rotor failures that have occurred in U. S. commercial aviation during 1978. These statistics are based on data compiled from the Flight Standards Service Difficulty Reports (SDRs) that were published by the Department of Transportation, Federal Aviation Administration (FAM). The compiled data were analyzed to establish:

- l. The incidence of rotor failures and the incidence of contained and uncontained 2 rotor fragments.
- 2. The distribution of rotor failures with respect to engine rotor component; i.e., Tan, compressor or turbine rotors and their rotating attachments or appendages such as spacers and seals.
- 3. The type of rotor fragment (disk, rim or blade) typically generated at failure.
 - 4. The cause of failure.
 - 5. The type of engines involved.
 - 6. The flight condition at the time of failure.

RESULTS

- 1. The data used for analysis are contained in APPENDIX A. The results of these analyses are shown in Figures 1 through 7.
- a. Figure 1 shows that 166 rotor failures occurred in 1978. These rotor failures accounted for approximately 8.4% of the 1971 shutdowns experienced by the gas turbine powered U. S. commercial aircraft fleet during 1978.

¹NASA DPR C-41581-B, Mod. 8.

²An uncontained rotor failure is defined as a rotor failure that produces fragments which penetrate and escape the confines of the engine casing.

NAPC-PE-23

Rotor fragments were generated in 125 of the failures experienced and, of these, 19 (15.2% of the fragment producing failures) were uncontained. This represents an uncontained failure rate of 3.6 per million gas turbine engine powered aircraft flight hours, or 1.1 per million engine operation hours. Approximately 6.8 million and 21.4 million aircraft flight and engine operating hours, respectively, were logged by the U. S. commercial aviation fleet in 1978.

- b. Figure 2 shows the distribution of rotor failures that produced fragments according to the engine component involved -- fan, compressor, turbine; the types of fragments that were generated; and the percentage of uncontained failures according to the type fragment generated. These data indicate that:
- (1) The incidence of turbine rotor fragment producing failures was approximately two times greater than that of compressor rotor fragment producing failures; these corresponded to 60% and 34.4%, respectively, of the total number of rotor failures. Fan rotor failures accounted for 5.6% of the fragment producing failures experienced.
- (2) Blade fragments were generated in 95.2% of the rotor failures; 13.4% of these were uncontained. The remaining rotor fragments failures (4.8%) produced disk, rim and seal fragments, of which 100%, 33.3% and 50%, respectively were uncontained.
- c. Figure 3 shows the rotor failure distribution among the types of engines that were affected, and the total number of that type engine in use.
- d. Figure 4 shows what caused the rotor failures to occur. Of the known causes of failure (1), the dominant causal factors were: (1) Secondary Causes (44.2%); (2) Foreign Object Damage (FOD) (31.7%), and (3) Design and Life Prediction Problems (19.2%).
- e. Figure 5 indicates the flight conditions that existed when the various rotor failures occurred. Approximately 65% of the 166 rotor failures occurred during the takeoff and climb stages of flight. Approximately 68% of the rotor fragment producing failures, and 79% of the uncontained rotor failures, occurred during these same stages of flight. The highest percentage of uncontained rotor failures (53%) were experienced during takeoff.
- f. Figure 6 is a cumulative tabulation that describes the distribution of uncontained rotor failures according to fragment type, engine component involved, cause category and flight condition (2) for the years 1976, 1977 and 1978. This figure will be expanded yearly to include all subsequent uncontained rotor failures. These data indicate that: for "design and life prediction problems"

⁽¹⁾ Because of the high percentage of unknown causes of rotor failure, the percentages were based on the total number of known causes.

⁽²⁾ Takeoff and climb are defined as "High Power", all other conditions are defined as "Low Power".

the numbers of uncontained failures were two times greater at "high" power than "low" power (namely 10 and 5); but for all other causes, the prevailing condition was "high power". Additional conclusions should become evident from this table with 'he accumulation of future data.

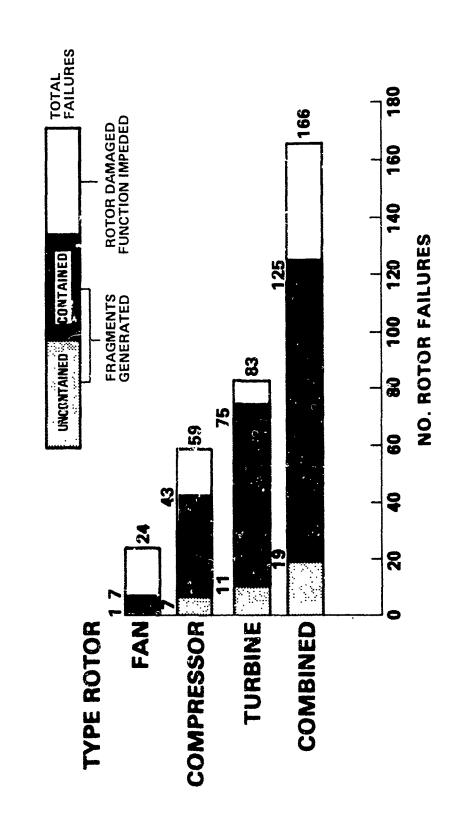
g. Dirice 7 shows the annual incidence of uncontained rotor failures in commercial aviation for the years 1962 and 1978. During 1978, the incidence of uncontained rotor failure increased by four over the previous year, 1977. Over the past five years, 1974 through 1978, an average of 16.2 uncontained rotor failures per year have occurred. During this same time period, the rate of uncontained rotor failures has remained relatively constant at an average of approximately one per million engine operating hours.

CONCLUSIONS

- 1. The incidence of rotor failure and uncontained failure is significantly righ or the to tarrant continuation of the experimental and analytical efforts that continuation of the experimental and analytical efforts that continue the RFPP.
- 2. , all types of fragments generated at rotor failure, disks and fan blade fragments, because of their size and high energy content, continue to be the threat that must be addressed in the RFPP.
- 3. It appears that causes such as FOD, structural life and integrity prediction, and secondary effects, are primarily responsible for most of the rotor failures that occur. Progress in the ability to predict structural life is being made through numerous programs sponsored both by Government agencies and by industry. The capability to reduce the causes of failures from secondary effects, such as bearing or seal failures, also is being addressed through technological programs. However, causes due to FOD still appear to be beyond the control or scope of present technology.

IN U.S. COMMERCIAL AVIATION 1978 INCIDENCE OF ROTOR FAILURE

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COMPONENT AND FRAGMENT TYPE DISTRIBUTIONS FOR CONTAINED AND UNCONTAINED ROTOR FAILURES(1) - 1978

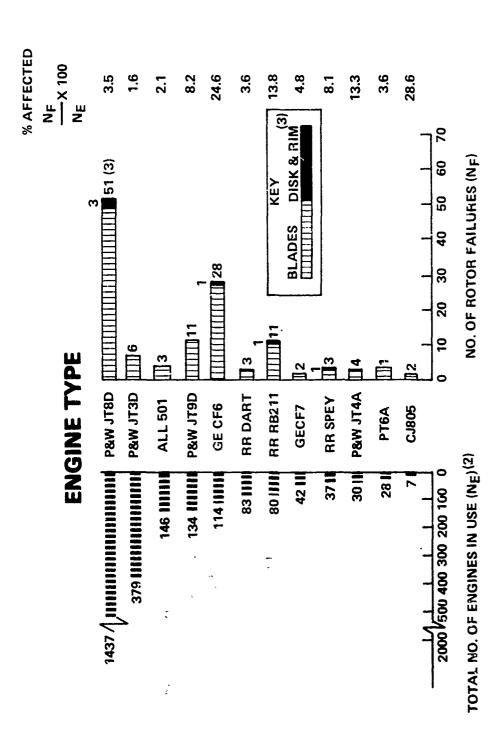
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THE INCIDENCE OF ROTOR FAILURE⁽¹⁾ IN U.S. COMMERCIAL AVIATION ACCORDING TO ENGINE TYPE AFFECTED - 1978

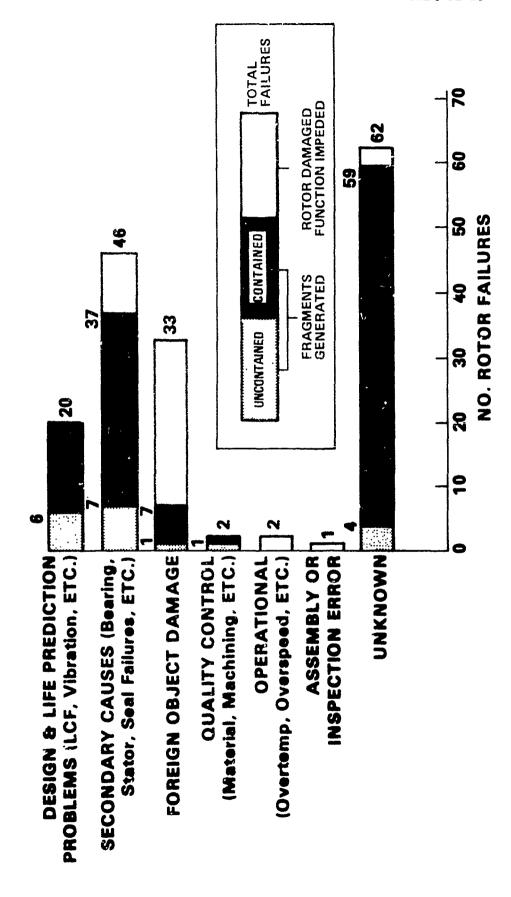


NOTES: (1) FAILURES THAT PRODUCED FRAGMENTS
(2) YEARLY AVG. OF AIRCRAFT IN USE AT END OF EACH MONTH
(3) 2 SEAL/SPACER FAILURES INCLUDED IN DISK/RIM COMPILATION

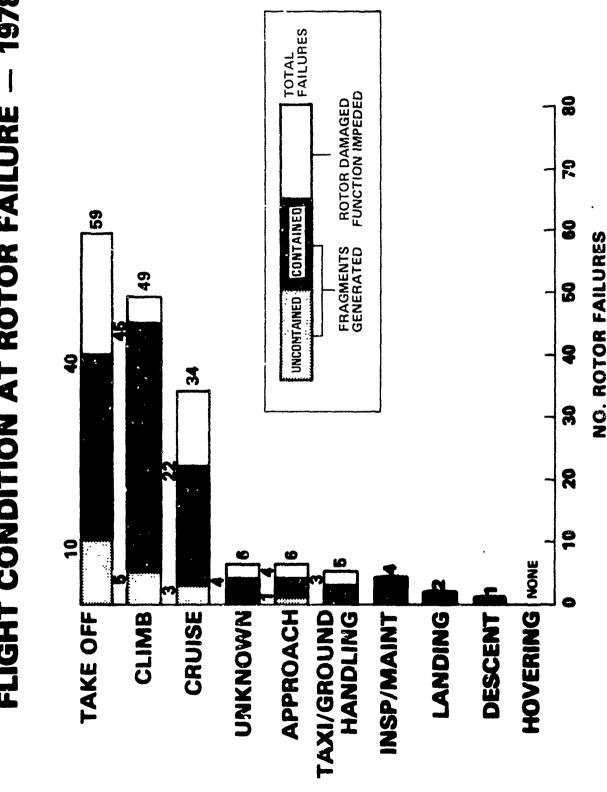
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FLIGHT CONDITION AT ROTOR FAILURE



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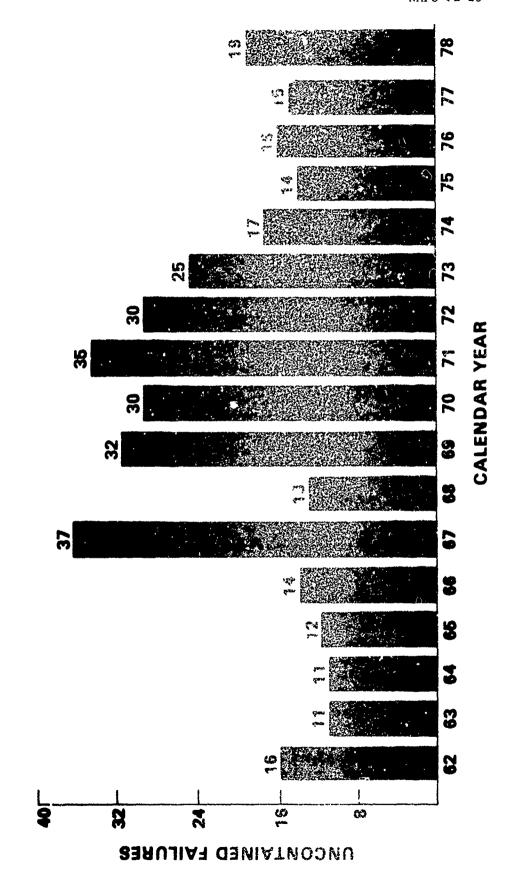
ACCORDING TO CAUSE AND FLIGHT CONDITION(1) UNCONTAINED ROTOR FAILURE DISTRIBUTIONS 1976 - 1978

		DESIGN & LIFE	LIFE	SECONDARY	DARY	FOREIGN OBJECT	OBJECT	QUALITY	<u>۲</u>					
TYPEOF	ENGINE	PRED. PROBLEMS	SW3-18C	CAUSES		LAMAGE		CONTROL	or or	UNKNOWN	NWC	SUBTOTALS	TALS	
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GENERATED	COMPONENT	POWER	POWER	POWER	POWER	POWER	POWER	POWER	POWER	POWER	POWER	PO'VER	POWER	
	FAN											0	0	
DISK	COMPRESSOR	ı										-	0	
	TURBINE		2									0	2	ო
	FAN											0	0	
Z.	COMPRESSOR	2								2		4	0	
	TURBINE							-				1	0	S
	FAN	3	1			က	-	2				8	2	
BLADE	COMPRESSOR	3		2						L)		10	0	
	TURBINE	1	2	6	-					2	2	12	2	37
	FAN											0	0	
SEAL	COMPRESSOR									1	-	ι-	-	
	TURBINE			2						1		က	0	ເກ
SUBTOTALS	TS ST	10	. بي	13	1	ဗ	-	8	0	11	е	640	10	
TOTALS			15	1	14	7		3	-	-	14	9	50	90

(1) TAKEOFF AND CLIMB ARE DEFINED A\$ "HIGH POWER," AND ALL OTHER CONDITIONS ARE DEFINED AS "LOW POWER."

THE INCIDENCE OF UNCONTAINED ROTOR FAILURES IN U.S. COMMERCIAL AVIATION 1962 - 1978

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APPENDIX A

Data on Rotor Failures in U. S. Commercial Aviation for 1978. Compiled from the Federal Aviation Administration Service Difficulty Reports.

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DATA COMPILATION KEY:

Component Code:

- F Fan
- C Compressor
- T Turbine

Fragment Type Code:

- D Disk
- R Rim
- B Blade
- S Seal
- N None

Cause Code:

- 1 Design and Life Prediction Problems
- 2 Secondary Causes
- 3 Foreign Object Damage
- 4 Quality Control
- 5 Operational
- 6 Assembly and Inspection Error
- 7 Unknown

Containment Condition Code:

- C Contained
- NC Not Contained
- N No Fragments Generated

Flight Condition Code:

- 1 Insp/Maint
- 2 Taxi/Grnd Hdl
- 3 Takeoff
- 4 Climb
- 5 Cruise
- 6 Descent
- 7 Approach
- 8 Landing
- 9 Hovering
- 10 Unknown

1978	
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FAILURES	
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CHARACTERISTICS	

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FLIGHT	4	7	4	4	r	2	æ	ω	n	m	4	S.				
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FRAGMENT	щ	щ	ф	щ	щ	Ф	_				•		,-	ю	2	7
COMPONENT	- E4	1	ഥ	I.	ย	H	E	α υ	ф	m E.	eq.	щ	щ	Д	щ	Д
ENGINE	JT4D	JT8D	JT8D	CF6	JT8D (CF6	JT8D	JT8D C	JT8D C	CF6 C	JT8D I	JIBD C	лтвр с	TT9D F	JT4A T	CF6 C
AIRCRAFT	B707	620	620	DC10	B727	DC10	B727	600	B727	DC10	B727	B727	600	DC10	B707	DC10 C
SUBMITTER	TWA	OZA	AWI	CAL	BNF	AAL	PSAX	AAA	BNF	TIAS	AAL 1	UAL	AWI I	NWA L	TWA E	AAL D
DATE	1/6	1/1	1/9	1/6	1/30	1/14	2/2	1/4	1/11	2/3	1/19	1/23	2/15	2/4	2/14	2/14
SDR NO.	01258018	01258019	01258020	01308023	01308024	02028023	0208026	0208025	01308024	02038024	02078027	02098006	02158020	03068028	03078020	03088024

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CHARACTERISTICS OF ROTOR FAILURES - 1978

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03168024	2/26	TWA	B707	JT3D	υ	Ø	2	υ	ч
03168025	2/18	OZA	620	JTBD	E	Ø	т.	NC	ĸ
03178023	2/26	AAL	DC10	CF6	E	щ	2	NC	4
03218019	2/27	AAA	BA111	SPEY	E	ø	2	υ	æ
03238023	2/28	AAL	000	CF6	E	В	T.	ບ	4
03248023	2/24	APN	CV580	501	H	ф	7	υ	7
03248024	3/2	TWA	900	JT8D	Ħ	æ	7	υ	m
03318024	3/8	OZA	620	JT8D	H	щ	2	NC	7
04058023	3/4	PCTC	066AD	CJ805	Н	ф	7	ບ	иì
04058026	2/26	EAL	11011	RB211	E	ф	7	U	e
04128024	3/19	NWA	0000	JE9D	E	ф	7	υ	4
04138023	3/21	NAL	B727	JTBD	υ	Д	7	υ	2
04138024	3/18	NAL	B727	JT8D	£4	Д	7	NC	၉
04138025	3/19	AAA	DC9	JTBD	E+	щ	7	υ	e
04148031	3/27	TXI	DC9	JT8D	Ħ	Д	7	υ	4

CHARACTERISTICS OF ROTOR FAILURES - 1978

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CAUSE	۲۷	-	H	н	7	7	7	7	7	5	8	7	7	2	7	C
FRAGMENT	В	æ	Д	Ω	Д	æ	ø.	Ф	Д	ф	£Ω	Ø	Ø	Ø	Ф	_
COMPONENT	E4	ט	υ	ບ	E	E										Ø
ENGINE	JT8D	JT8D (JT9D (JT8D (JTBD	JT:8D	JT8D T	JT8D T	JT8D T	этзр с	JT8D T	CF6 T	DART T	RB211 T	CF6 C	CF6 T
ALRCKAFT	B727	62Q	B747	DC9	600	B727	620	B727	, 620	DC8	600	DC10 (FH227 I	11017	0100	DC10 C
SUBMITTER	NAL	TXI	AAL	HAL	AWI	NAL	OZA	NAL	AAA	CAPS	TXI	WAL	OZA E	I'WA I	WAL D	UAL D
DATE	3/27	3/27	3/30	4/3	4/4	4/20	4/24	4/22	4/22	4/2	4/28	5/1	5/1 (5/4	5/12	5/18 t
SDR NO.	04188030	04198037	04218038	04278029	05018034	05048032	05098036	05108028	05108029	05118034	05118035	05168030	05188029	02188030	05268023	05318018

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CHARACTERISTICS OF ROTOR FAILURES - 1978

SDR NO.	DATE	SUBMITTER	AIRCRAFT	ENGINE	COMPONENT	FRAGMENT	CAUSE	CONTAINMENT	FLIGHT
06018025	5/21	AAL	B727	JTBD	E	Д	2	NC	ю
060288026	5/20	TWA	11011	RB211	Ð	Д	7	υ	4
06078026	5/25	AAA	BA111	SPEY	H	æ	7	ပ	m
06088026	5/30	TWA	L1011	RB211	ບ	æ	7	υ	е
06128024	5/26	AAA	DC9	JT8D	E	æ	7	U	e
06148023	5/19	NAL	DC10	CF6	ĒŦ	В	2	υ	4
06218024	6/12	AAL	B727 ·	JT8D	£.	æ	7	NC	3
06268016	01/9	UAL	B747	OT.	ပ	ф	н	Ü	4
06278020	6/9	WAL	DC10	CF6	E4	Ø	7	NC	Ŋ
06298019	61/9	UAL	DC10	CF6	ပ	В	7	ບ	rs S
06298019	6/21	TIAS	DC10	CF6	ပ	В	н	U	S.
06308024	6/21	FAL	CV580	501	ပ	Ø	7	υ	9
06308025	6/17	EAL	B727	JTBD	£	щ	н	NC	:5
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07078026	6/23	UAL	DC10	CF6	£.	Д	н	ပ	æ

CONDITION FLIGHT CONTAINMENT 2 CAUSE Fragment Type CHARACTERISTICS OF ROTOR FAILURES - 1978 COMPONENT ENGINE RB211 σ JTBD JT3D JTBD σ JT8DJTBDJT8DCF6 CF6 CF6 CF6 CF6 CF6 CF6 JT.4 AIRCRAFT 11011 000 DC10 DC10 DC10 DC10 0100 DC10 B747 B747 B727 B727 B707 DC9 DC8 620 62 SUBMITTER CAPS AAA UAL WAL DAI, AAA SE AAA AAL TAN NAL TWA UAL AAL CAL NAL UAI, DATE 8/19 6/23 7/15 7/14 7/24 8/17 6/27 6/17 7/27 8/17 8/21 6/27 7/27 2/3 9// 8/8 1/1 08318030 07218026 07248018 07258020 07318019 08018023 08118020 08318029 09018029 07148024 07268027 08178023 08178024 08308023 08318028 07178024 07278021 SDR NO.

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		CHARACTER	ISTICS OF	CHARACTERISTICS OF ROTOR FAILURES - 1978	RES - 1978			
DATE	SUBMITTER	AIRCRAFT	ENGINE	COMPONENT	FRAGMENT	CAUSE	CONTAINMENT	FLIGHT
8/21	FAL	B737	лтвр	H	ф	7	ပ	4
9/1	EAL	11011	RB211	ပ	æ	7	ບ	
8/25	AAL	B727	σтвр	ŭ	æ	2	υ	4
8/29	UAL	DC10	CF6	Ü	Ф	ᡤ	ပ	4
8/27	WAA	B737	JT8D	H	Ω	2	ပ	7
8/29	FECZ	MD30	CF7	Ħ	Ø	7	ပ	4
8/23	FECZ	MD30	CF7	E	Ф	7	υ	4
1/6	AAL	DC10	CF6	U	щ	ı	NC	4
9/6	DAL	L1011	RB211	υ	ф	7	υ	4
9/13	ACAX	L188	501	H	Д	2	υ	ю
9/19	PSAX	Unknown	JT8D	ĒΨ	Ø	7	υ	-
8/6	NAL	B727	JTSD	υ	മ	7	υ	4
9/14	UAL	DC8	JT3D	υ	ф	7	υ	2
9/22	TWA	B747	JT9D	£	ø	7	ບ	4
9/27	AAIX	B720	JT3D	υ	Ø	7	ບ	m
10/4	TWA	11011	RB211	E	щ	7	υ	m

CONDITION

SDR NO.

CHARACTERISTICS OF ROTOR FAILUNES - 1978

FLIGHT	4	ო	ო	4	4	S.	7	4	e e	ო	4	4	4	ო	8	J.	4
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CAUSE	н	က	7	н	7	73	7	7	7	7	7	7	-	7	8	m	ď
FRAGMENT	Д	æ	Ø	щ	Д			_									
COMPONENT	v	ر ن	7 1	r U	C E	g U	T. B	73 B	E B	E B	α υ	д С	T. B	ຜ	m E.	m	æ
FNGINE	JT8D	JT8D	SPEY	CF 6	RB212	RB211	DART532	JTBD	JTSD	JTBD	JT8D () детъ	CF6 1	JIBD C	JT8D T	OTT9D C	JT8D T
AIRCRAFT	B727	B727	BAlll	DC10	11011	11011	FH227	620	620	B727	B727	B747	DC10	B727	DC9	B747	600
SUBMITTER	NAL	TWA	AAA	NAL	DAL	TWA	OZA	AAA	AAA	BNE	TWI	UAL	UAL	UAL	OZA I	NT.7A E	AWI D
DATE	10/18	10/26	10/8	10/26	11/1	11/6	11/13	11/13	11/13	12/1	11/20	12/26	11/28	12/3 U	11/25 0	12/5 N	12/4 A
SDR NO.	11038022	11078022	11098027	11148021	11228022	11219025	12018027	12058026	12058027	12068015	12128023	12148024	12208017	12208018	12218014	12228024	12268028

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SDR NO.	DATE	SUBMITTER	AIRCRAFT	ENGINE	COMPONENT	FRAGMENT	CAUSE	CONTAINMENT	FLIGHT
12298025	12/13	AAL	B727	JTSD	E	ф	7	υ	4
12298027	12/12	PAI	YSIIA	DART	E	ф	7	S	м
01039024	12/13	CAL	0010	CF6	υ	Д	7	NC	т
01039026	11/30	RAHT	SH3	PT6A	E	щ	7	υ	ч
01059025	12/19	FAL	B737	JT8D	H	щ	7	ပ	រោ
01099026	12/17	AWI	DC9	JTSD	Ēι	ф	4	Ü	m
01099027	12/18	NWA	DC10	JT9D	ĹΉ	Д	ю	NC	ស
01159024	12/19	DAL	DC8	JT3D	υ	ф	7	υ	10
01169024	12/23	PCTC	06602	CJ805	Ħ	В	2	ပ	10
03029031	12/29	CAPS	DC8	JT4A	£	Д	7	υ	ស
01099025	12/17	OZA	620	JT8D	υ	z	7	z	m
01258025	1/11	CAIT	SD330	PT6A	ບ	z	77	z	2
02018025	1/16	TWA	DC9	JT8D	Ē4	z	m	z	м
02038026	1/18	NAL	B727	JT8D	E	z:	7	Z	ю
02088023	1/22	TWA	B727	JT8D	Ēι	z	m	z	N
02098022	1/19	ACAX	L188	501	ပ	z	m	z	4
02098023	1/23	TWA	B707	JT3D	ម	z	æ	z	m,

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			CHARACT	CHARACTERISTICS	OF ROTOR FAILURES	- 1	1978		
SDR NO.	DATE	SUBMITTER	AIRCRAFT	ENGINE	COMPONENT	FRAGMENT	CRUSE	CONTAINMENT	FLIGHT
02108026	1/22	SBWS	B747	JT9D	υ	z	7	z	4
0308029	8/2	ONAS	DC10	CF6	ĒΨ	z	m	z	2
03098031	2/2	FWIC	CV880	CJ807	υ	z	:	z	10
03108025	3/10	ZIAX	STC340T	DART	E	z	7	Z	е
03208026	2/27	AAA	BA111	206	υ	z	m	z	5
03278024	3/5	TWA	B707	JT3D	υ	z	ю	z	Z.
03308021	2/26	FLAX	1188	501	Ţ	z	9	z	S)
04038016	3/12	FAL	B737	JT.8D	Œ	z	ю	z	ю
03278011	3/21	OZA	620	JT8D	ĒΨ	z	ю	Z	ю
04058021	4/5	FAL	B737	JTBD	ſτι	z	ю	Z	ю
02228030	2/2	WAL	B720	JT3D	υ	z	7	z	ю
04268015	4/26	HAL	620	JT.8D	ĹΉ	z	т	z	ю
05098037	4/23	UAL	B737	JT8D	Įż,	z	т	Z	ю
05108027	4/20	NAL	B727	JTBD	Ü	z	Ŋ	z	22
05188027	4/29	OZA	620	JT8D	E	Z	7	N	ស
05248021	9/9	FECZ	MD20	CF7	U	z	m	N	ю
05268024	5/12	WAA	B737	TT8D	<u> </u>	z	ю	Z	7

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COMPONENT	ÍΨ	ધિ	υ					i 2	; 2	.		3 2	: 2	: 2	: 2	: z	z
ENGINE	TBD CBTC	RB211	501	CJ805 T	501 T	CF6 C	JT3D C	JT8D T	501 C	JT8D F		,	1 C	JE3D C	-	3D F	30
AIRCRAFT	B737	נוסוז	CV580	CV990	L382 5	DC10 C	B707 J	B727 J	L382 5(DC9 JT	B737 J	MD20 CF7	L382 501		FH227 DART	27 JTBD	9 JT8D
SUBMITTER	PAI	EAL	APN	NOMC C	TIAS I	NAL D	TWA B	TWA B	TIAS	OZA DO	FAL B	FECZ ME	TIAS L3	L DC8		L B727	L DC9
DATE	97/9	7/11	7/14	1/8	7/31	8/5	8/3 1	8/30 I	в/19 т	10/15 0	10/27 E	10/13 F	11/16 T	11/13 UAL	11/13 OZA	12/27 UAL	12/30 HAL
SDR NO.	07078027	07268026	07318018	08038020	08178022	08218022	08218024	09158025	10038023	11018008	11148024	11228020	11298023	12058024	12068018	01199026	02019020

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